

Work Order ID 55696

January 27, 2010 2:57:04 PM



Page 1

Item ID: D3166-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Hoop

Start Date: 1/27/10 Start Qty: 12.00



Cust Item ID:

Required Date: 2/02/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

[Signature]

Date: 10-1-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3166 | Rev A1 |

100 0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

Cut 3/4" x 3/4" square tubing 60.00" long.

SAD 10-2-01

(12)

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Form D3166-1 Basket Hoop as per Dwg D3166 using Bending program 350 BASB, and folio FT004.

[Signature]

10-2-1

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Inspect Basket Hoop dimensions with template D3166-1-T1 (DT8302)

⇒ 8.10.2.101

(x12)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 55696

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Page 2

Item ID: D3166-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Hoop

Start Date: 1/27/10 Start Qty: 12.00



Cust Item ID:

Required Date: 2/02/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *WA*

0.00



Packaging

Memo

0.00

Packaging

SAP 10-01-02

(12)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/04

MF 10-2-2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

January 27, 2010 2:57:09 PM

Page 1

Work Order ID: 55696



Parent Item: D3166-1

Parent Item Name: Basket Hoop

Start Date: 1/27/10

Required Date: 2/02/10

Comments: IPP A 02.08.23 New issue KJ
IPP: B 08.12.05 Updated bending program on step 3 per NCR W/O43165 KJ
Verified by: EC
IPP Rev: C 09-01-23 as per DEO D3166-A2 DD verified by: EC

Start Qty: 12.00

Required Qty: 12.00

M304TS0.750W.065

Purchased

No

100

f

293.2638 63.1579



SAD 10-02-01

304 SQ Tube .75x.75x.065W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

293.2637742

113082

0.00419

113245

43.7858842

113683

249.4737

Main Warehouse

WA

0.0000047

112398

0.0000047

M 113 836 ==> 63.1579

| W/O: | | WORK ORDER CHANGES | | | | | |
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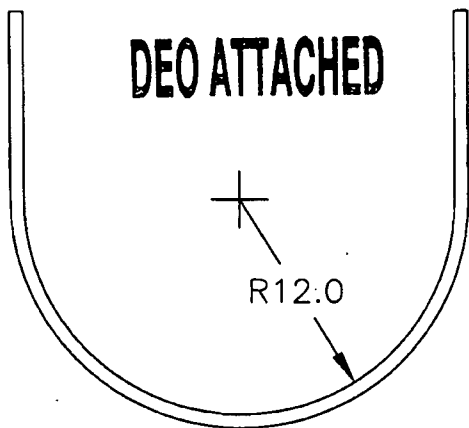
NOTE: Date & initial all entries



| | | | |
|------------------|----------------|---|------------------------|
| DESIGN # | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3166 | REV. A SHEET 1 OF 1 |
| DATE 02.07.10 | | TITLE BASKET HOOP | SCALE NTS |
| A | 02.07.10 | NEW ISSUE | |
| A1 | 04.04.08 | 38+/-1 WAS 36.0 | |

RELEASED
02.08.06

DEO ATTACHED



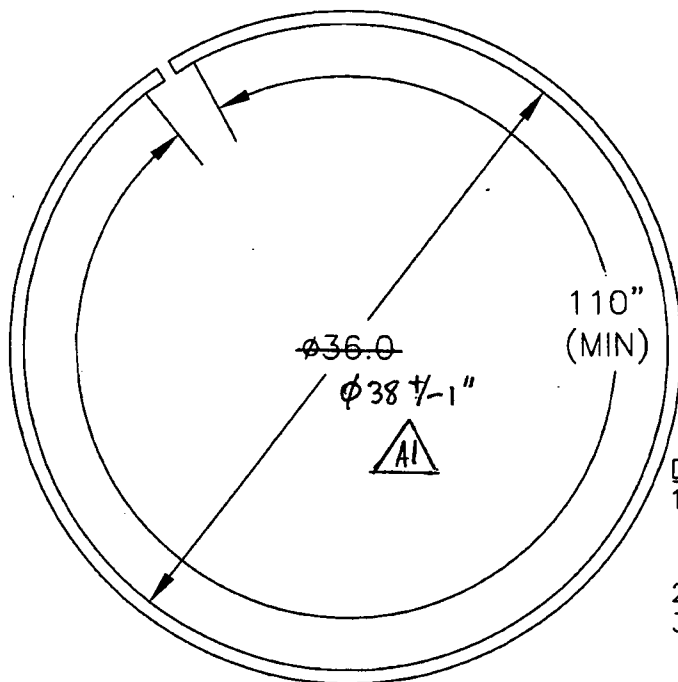
10.6 (REF, NEED 8.0 MIN)

D3166-1 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 60.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35696

10-1-27



D3166-3 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 120.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| | | | | | | | |
|----------------------|------------------------|---------------------------|---|--|-------------------------|---------------------|--------------|
| DRAWING NO. D3166 | TITLE BASKET HOOP | REV A1 | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D3166-A-2 | SHEET NO. 1 OF 1 | SCALE NTS |
| DRAWN AJS | CHECKED [Signature] | MFG. APPR. [Signature] | APPROVED [Signature] | | DE APPR. [Signature] | | |
| DATE 08.12.11 | DATE 08.12.15 | DATE 08/12/15 | DATE 08/12/16 | | DATE 08.12.16 | | |

1) MODIFY MATERIAL NOTE FOR D3166-1 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,
60.00" LONG
REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 60.00" LONG
(REF DART SPEC. M304TS0.750W.063)

2) MODIFY MATERIAL NOTE FOR D3166-3 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,
120.00" LONG
REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 120.00" LONG
(REF DART SPEC. M304TS0.750W.063)

RELEASED
08/12/16 [Signature]

REASON: SEE PAR 08-005

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W/O 55696

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NOTE: Date & initial all entries